

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019901**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Travelers**Summary of Items Observed:**

Quality Assurance (QA) Inspector, Kevin Carpenter arrived at the Westmont Industries facility in Santa Fe Springs California to observed in-process fabrication of SAS Superstructure Travelers. QA observed the following approved welders continuing to performing FCAW welding on the E2/E3 traveler sections listed below.

QA observed approved welder Eutimo Lopez, (WID #3035) performing FCAW welding on Traveler assembly frame #8-B327. Welding performed involved welding various gusset plates, tube flare-groove welding and fillet welds.

QA observed approved welder Juan Jimenez, (WID #3049) performing FCAW welding on gusset plates to diagonal tube steel on the Traveler assembly frame #7-A327. Welding performed involved welding various gusset plates, tube flare-groove welding and fillet welds.

QA observed approved welder Charles Newton, (WID #3200) performing FCAW welding on diagonal tube steel on the Traveler South East assembly frame #7-A317. Welding performed involved welding various gusset plates, tube flare-groove welding and fillet welds.

QA observed approved welder Jose Rodriguez, (WID #3031) performing FCAW welding on diagonal tube steel on the Traveler South Side assembly frame #7-A317. Welding performed involved welding various gusset plates, tube flare-groove welding and fillet welds.

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QA observed approved welder Cesar Canales, (WID #3195) performing FCAW welding (fit-up and tacking) on the Traveler assembly frame #8-B327. Welding performed involved welding various gusset plates, tube flare-groove welding and fillet welds.

QA observed QC performing quality checks on completed welds and performing the monitoring of in-process welding including checking the welding parameters, amperage, voltage and travel speed of the welders listed above.

QA observed in-process FCAW welding and performed random visual inspection of completed welds. QA noted no non-conforming items. Please see photographs below.



Summary of Conversations:

No notable conversations made.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Carpenter, Kevin	Quality Assurance Inspector
Reviewed By:	Edmondson, Fred	QA Reviewer
